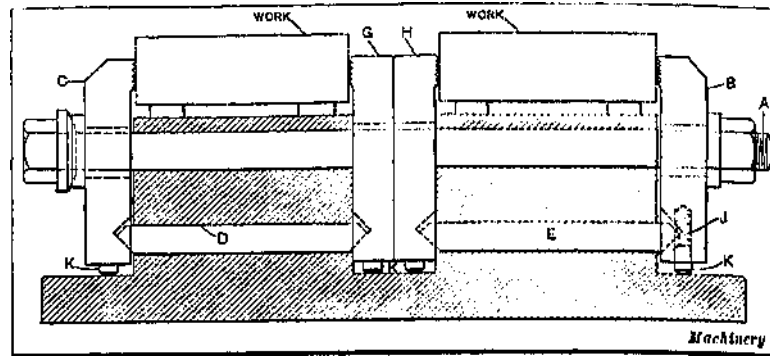


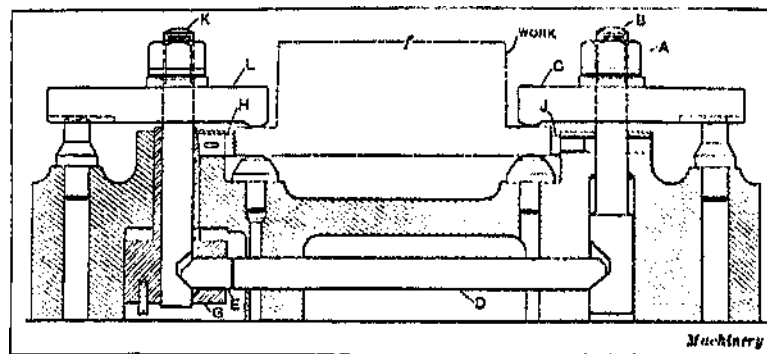
Fig. 12 illustrates a center clamp that gives a downward and outward thrust by means of the tapered ends of plate *A*, which is carried by plunger *B*. Plunger *C* wedges down the plunger *D*, which is tapped into plunger *B*. Plungers *B* and *D* are held up



**Fig. 9. Mechanism for  
Drawing down  
Both  
ends of  
Two  
Pieces  
by a  
Single  
Nut**

by a spring *E*. A small pin in plunger *D* allows a half turn of plunger *B* so that the work may be lifted out.

In the fixture illustrated in Fig. 14, the work (two clutch shells) is equalized and clamped by a single movement of the handwheel



**Fig. 10. Method for  
Drawing down Two Clamps  
and Forcing the  
Work against the Stop-pin**

**by** a Single Clamping  
Operation

*Bj* drawing out rod *C* against the collar ***D***. The section *A A* shows how this collar equalizes its thrust with plungers *E* and *P*. The collar *D* is free to slip to either side as required for equalizing. The plungers *E* and *F* draw in rods *G and H* through